

## ABSTRACT OF THE DISCLOSURE

A mold of a casting machine is filled to make a cast article. The method includes providing a molten metal to a casting chamber in fluid communication  
5 with the mold, the casting chamber having a supply conduit for introducing a gas into the casting chamber, and the casting chamber having an evacuation conduit for delivering the molten metal from the casting chamber to the mold. The method also includes controlling the filling of the mold during a first time interval by delivering the molten metal from the casting chamber to the mold at a  
10 first rate. The method further includes controlling the filling of the mold during a second time interval by delivering the molten metal from the casting chamber to the mold at a second rate. The filling of the mold decelerates from the first rate to the second rate and the second rate does not exceed the first rate.